

Date: Thursday, 11/12/2008 10:07:47 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : R44 WEARPLATE
Job Number : 43980	
Estimate Number : 12651	
P.O. Number :	Part Number : D35651
This Issue : 11/12/2008 S.O. No. :	Drawing Number : D3565 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / /	Drawing Revision : C
Previous Run : 36487	Material :
	Due Date : 22/12/2008
Written By :	Qty: 6 Um: Each
Checked & Approved By : <u>JUL 08.12.11</u>	
Comment : Est Rev :A New Issue 07-01-16 JLM	
est rev B revB dwg 07.04.18 ec	
Est Rev:C rev.c as per dwg 08-01-14 DD verified by:	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S16GA	304/316 Sheet .063
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Comment: Qty.: 0.1418 sf(s)/Unit Total : 0.8505 sf(s)
 304/316 .060 Sheet
 Batch: 109057 IB 8-12-12

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3565
 Dwg Rev: C
 Prog Rev: C

IB 8-12-128

2-Deburr if necessary

IB 8-12-12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5 08/12/12 (78)

5.0	D30093	Cup
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)
 CUP
 Batch: B41176

IB 8-12-12 L24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/12/2008 10:07:47 AM
User: Julie Dawson

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Drawing Name: R44 WEARPLATE

Job Number: 43980

Part Number: D35651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3565

2-Weld hard facing as per Dwg D3565 using DT8991 jig

A/R 2059B Hard Coat rod

Batch:

M109963

EL 8-12-17

7.0

QC9



ACS
8/12/18

VISUAL WELDING INSPECTION



(Ph)

Comment: VISUAL WELDING INSPECTION

08.12.17

08.12.17

8.0

POWDER COATING

POWDER COATING



M109648



(8X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:20
320°F
1:30

MF 08/12/18

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(8)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FD 08/12/18

10.0

PACKAGING 1

PACKAGING RESOURCE #1



(8X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Store

8/12/18

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-12-18

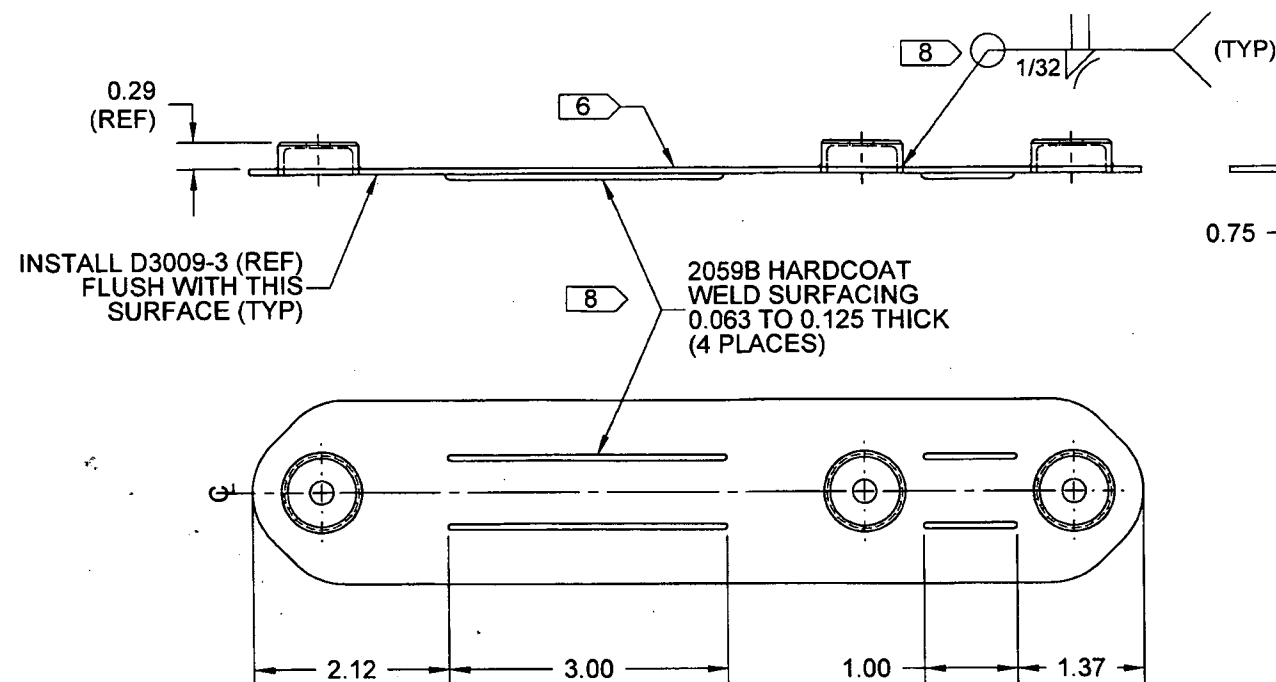
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
01/11/12	#70	Perment change ADD QC #5 inspection after Qc 9					01/01/12	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

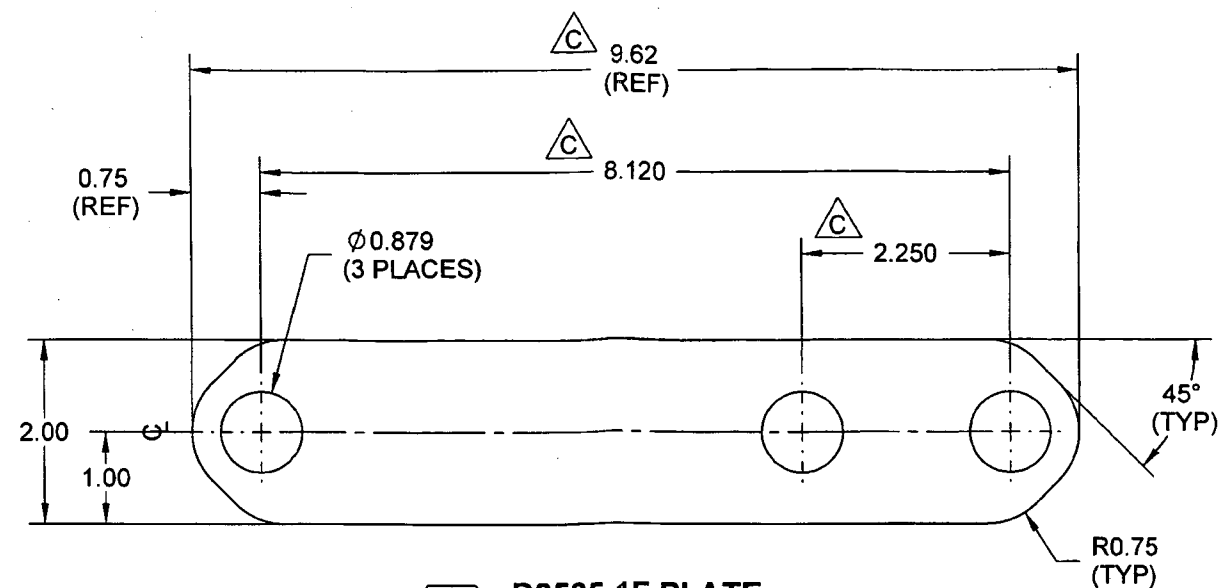
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

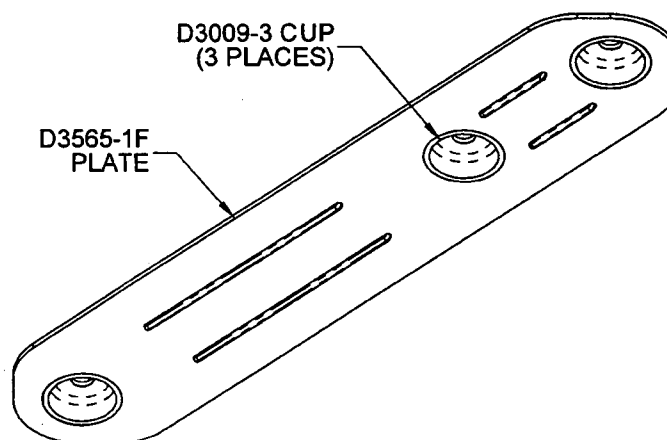
NOTE: Date & initial all entries



D3565-1 R44 WEARPLATE



D3565-1F PLATE



D3565-1 PARTS LIST

QTY	P/N	DESCRIPTION
X	D3565-1	R44 WEARPLATE
1	D3565-1F	PLATE
3	D3009-3	CUP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK) PER MIL-S-5059 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3565-1" AND B/N "BXXXXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) WELD PER DART QSI 004
- 9) PART IS SYMMETRIC ABOUT ϕ

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RETURN TO
ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4518

RELEASED
06-01-11

C	WEARPLATE NOW WELDED (C7); 8.120 WAS 8.220, 2.250 WAS 2.300 (D2); ADDED PARTS LIST (B7); UPDATED NOTES (A7)	MB	07.12.14
B	8.220 WAS 8.120; 2.300 WAS 2.250; ADD HOLE DIMS AFTER CUP FORMING	CB	07.03.12
A	NEW ISSUE	CB	07.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN	CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JP		
CHECKED	JP	DRAWING NO.	REV. C
MFG. APPR.	JP	D3565	SHEET 1 OF 1
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	R44 WEARPLATE	1:2
DATE	07.12.14	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

